

Work Order ID 71681

Thursday, July 07, 2011 12:12:56 PM



Page 1

Item ID:	D3259-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Doubler					
Start Date:	7/7/2011	Start Qty: 8.00		Cust Item ID:		
Required Date:	7/21/2011	Req'd Qty: 8.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/07/07</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3259	Rev B								

100	FLOW WATER JET	0.00							
	Waterjet	Memo	0.00						
FLOW CNC Waterjet	I-Cut as per Dwg D3259	<input type="checkbox"/> Dwg Rev: <u>B</u>	<input type="checkbox"/> Prog Rev: <u>B</u>	<input type="checkbox"/> 2-					
<u>2824</u> <u>063</u>	Deburr if necessary								

IB 11-8-12

8

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	Memo	0.00						
Quality Control									

IB 11-8-12

120	QC8- Inspect parts - second check	0.00							
	QC	Memo	0.00						
Quality Control									

21062112

421

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3259-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 7/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 8.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-C'Sink Holes as per Dwg D3259

SB 11/08/15 (8)

140

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3259

SB 11/08/25

(8)

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 11/08/25

(48)

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Thursday, July 07, 2011 12:12:56 PM

Item ID: D3259-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 7/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

8x ✓ M-L 11/08/29

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/8/30

180

Identify as per dwg & Stock Location: *ST 180a* 0.00

Packaging

Memo

0.00

Packaging

*6**8x**Sp 11-08-30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D3259-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 7/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/30 [Signature]
ME
11-08-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 71681

Parent Item: D3259-3

Parent Item Name: Doubler



Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC IPP REV
B:AS PER REV B 10-05-19 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063

Purchased

No

100

sf

250.3800

1.388

11.68842

12.



B11-8-12

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT022

250.38

117018

25.88

117392

224.5

117392

8

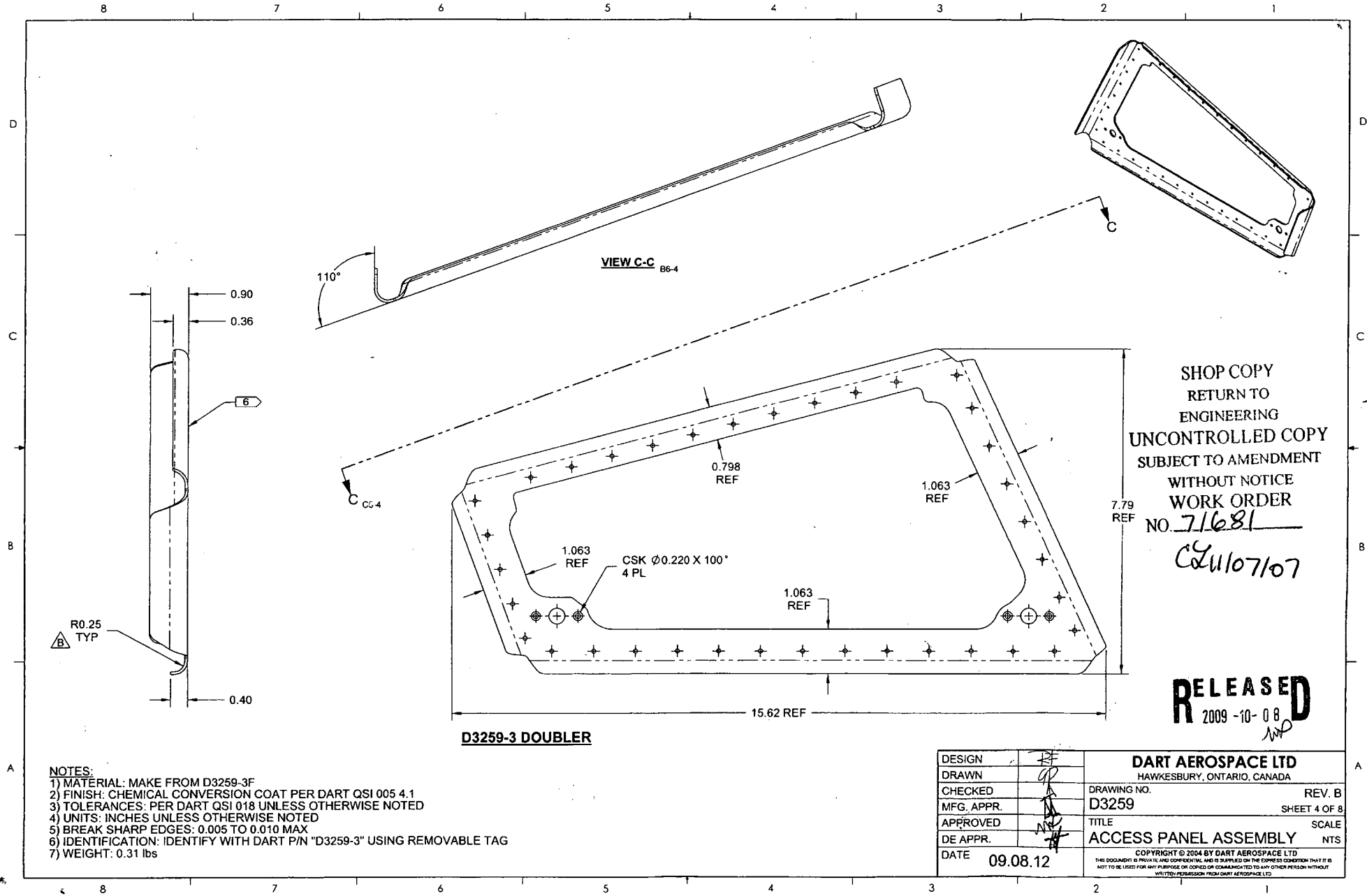
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3259-3 DOUBLER

NOTES:

- 1) MATERIAL: MAKE FROM D3259-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-3" USING REMOVABLE TAG
- 7) WEIGHT: 0.31 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71681
CZ1107/07

RELEASED
2009-10-08
MD

DESIGN	<i>RF</i>	DART AEROSPACE LTD	
DRAWN	<i>JP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JP</i>	DRAWING NO. D3259	REV. B
MFG. APPR.	<i>JP</i>	SHEET 4 OF 8	
APPROVED	<i>MD</i>	TITLE ACCESS PANEL ASSEMBLY	SCALE NTS
DE APPR.	<i>MD</i>	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
DATE	09.08.12	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order:	21681
Description: Doubler		Part Number:	D3259-3/-4
Inspection Dwg: D3259 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.000	+/-0.005	8.994	✓		PROWJ02	
1.000	+/-0.005	1.000	✓		UB02	
0.260	+/-0.010	.258	✓		✓	
R0.25	+/-0.030	.25	✓		R.G	
R0.50	+/-0.030	.50	✓		R.G	
5.000	+/-0.005	4.996	✓		✓	
0.875	+/-0.005	.873	✓		✓	
12.000	+/-0.005	11.999	✓		P	
3.500	+/-0.005	3.498	✓		✓	
0.875	+/-0.005	.876	✓		✓	
R0.13	+/-0.030	.13	✓		R.G	
0.500	+/-0.005	.499	✓		✓	
0.525	+/-0.005	.524	✓		✓	
1.80	+/-0.030	1.804	✓		✓	
Ø0.128	+0.005/-0.000	.129	✓		✓	
Ø0.377	+0.005/-0.000	.377	✓		✓	
Ø0.098	+0.005/-0.000	.102	✓		✓	
0.063 thick	+/-0.005	.063	✓		✓	
Grain Direction	N/A		✓			

Measured by: IB	Audited by: S	Preliminary Approval:
Date: 11-8-12	Date: 11/08/12	Date:

Rev	Date	Change	Revised by	Approved
A	04.08.25	New Issue P/O D412-705-019	KJ/JLM	
B	10.06.07	Dwg Rev updated	KJ	
C	10.08.03	Dimensions updated	KJ	

